

Work Order ID 78349

Thursday, January 05, 2012 3:00:19 PM

78349

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Item ID: D4004-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bottom Strap Attach Bracket
 Start Date: 1/6/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/27/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *mf* Date: *11-21-06* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4004	A

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00
 Jeaspa Bandsaw 1-Cut D3033-144 extrusion to length per D4004-5 detail of dwg D3033
 Ensure cut is started at correct place per dwg
 Batch: *68524*
 2-Deburr

105 0.00
105
 Small Fab Memo 0.00
 Small Fab Drill and c'sink holes as per dwg and trim part to length as required.

EP 12/01/30 (4)
EP 12/01/30 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/12/01/30					(74)
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							4 BR 12-1-30.
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							-d M 12/01/30

Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 78349

Parent Item: D4004-5

Parent Item Name: Bottom Strap Attach Bracket

Start Date: 1/6/2012

Required Date: 1/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD
562 DD verf:EC

IPP Rev:B 10.05.17 as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3033-144 Seat Track		Manufactured	No			100	f	45.8653	0.41	1.7263158		12/01/30	

Location

Loc Qty

Loc Code

ST489A

45.86526311

30209

0.5

58045

5.19684211

68524

5.668421 -

77193

34.5

1.7263158

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

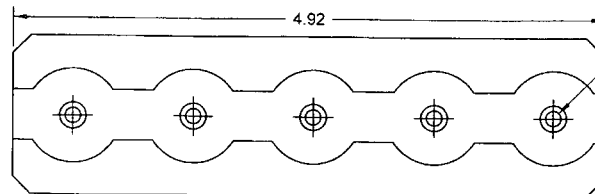
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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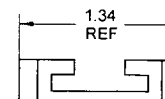
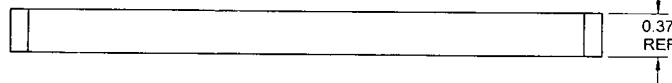
NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-5	JCA-M47-2-23



DRILL $\varnothing 0.129$ (#30 DRILL)
CONCENTRIC WITH SEAT TRACK
CSK $\varnothing 0.225 \times 100^\circ$
5 PL

CHAMFER $0.15 \times 45^\circ$
TYP




D4004-5 BOTTOM STRAP ATTACH BRACKET

RELEASED
2010-05-05
NP

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLINE P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-5" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

78349

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4004	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SIDE RESTRAINT	NTS
DATE	10.02.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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